



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3913-041
Job Sheet 166661-A



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/13/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	17-12-05
100	Large Fab	1 pcs	10/30/17	0.00	10.00	Large Fab 1	19-12-05
110	QC	1 pcs	10/30/17	0.00	0.00	QC9	PD 17-12-06
120	QC	1 pcs	10/30/17	0.00	0.00	QC5	PD 17-12-06
125	HandFinish	1 pcs	10/30/17	0.00	0.29	HandFinish2	BD 17-12-11
130	Powdercoat	1 pcs	10/30/17	0.00	0.93	Powdercoat2	SK 17-12-11
140	QC	1 pcs	10/30/17	0.00	0.00	QC3	17-12-12
150	HandFinish	1 pcs	10/31/17	0.00	0.50	HandFinish4	17-12-12
160	QC	1 pcs	10/31/17	0.00	0.00	QC5	38
170	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	17-12-12
180	QC21-SA	1 Ea	10/31/17	0.00	0.00	QC21	DEC 14 2017

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg

130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat

150 - Pick Kit

M/135467. START: 10:30 O.V.T: 375° FINISH: 11:00.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581-005842	2	28	0	0
	002297-D3913-1	1	1	0	0
	D3913-15 014390	1	12	0	0
	002108-D3913-3	1	3	0	0
	D3913-7 0009710	2	2	0	0
	010881-D3913-9	1	0	0	0
	D3916-041 015623	2	4	0	0
	012242-D3916-5	3	4	0	0
	D4016-1 009181	3	13	0	0
	004770-D4017-7	3	21	0	0
	D4017-9 009723	2	4	0	0
	005857-D4020-11	2	2	0	0
	D4021-1 010955	3	33	0	0
	3015127-D4034-041	1	2	0	0
	D4034-043 012965	1	2	0	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____

Step #: _____

QTY Effective : _____

MRB (QS1042) Approval

Description Work Order Deviation

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

DART
 AEROSPACE
S017787

Long Basket Base Assembly, 350

D3913-041

PART NO:
Revision:
Operation:
Change No:

Start up Operation

Mfg Date: 12/06/17
Job No: 166661-A

Root Cause			
Environment ☐	No Re-verifica ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvement ☐	Heat Treat ☐	
Substation ☐	Process Improvement ☐	Wave/Twist in Tube ☐	
Past Expiry Date ☐	Manufacturing Process ☐	Marks/Chatter ☐	
Misidentified ☐	Past Due ☐	OTHER : ☐	

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Positioned Wrong ☐
 Outside Dimensions ☐
 Over/Under tolerance ☐
 Part Incorrect ☐
 Part Lost/Missing ☐
 Part Moved ☐
 Drawing ☐
 Finish ☐
 Misread ☐
 Turning Sequence ☐

Wrong Stock Pulled ☐
 Out of Sequence ☐
 Off-set ☐
 Mislabelled ☐
 Fit/Function ☐
 Misaligned/off center ☐

150-HandFinish	009863 - D4672-1005866	2	7	0	0
	M304EX0.75-16F 500986333		321	0	0
	AN3-10A 5014736	6	38	0	0
	D2931 F86435-1	2	1,336	0	0
	D4021-5 ✓ 5021883	2	19	0	0
	MS20600-AD4W3 5019431	2	99	0	0
	MS21042L3 5016501	6	462	0	0
	NAS1149F0332P 5000570	12	1,231	0	0

1

Part Specifications

Specifications could not be found.

Plex 10/13/17 9:39 AM dart.poulin.mario

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								